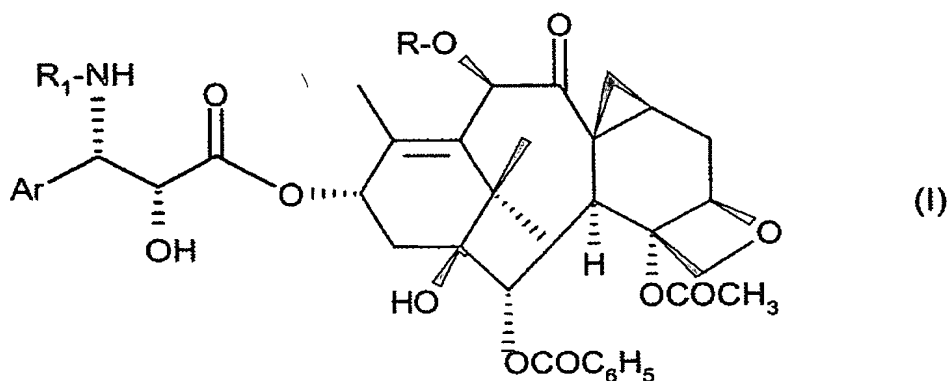


PROCESS FOR THE PREPARATION OF 4,10 β -DIACETOXY-2 α -
BENZOYLOXY-5 β ,20-EPOXY-1,13 α -DIHYDROXY-9-OXO-19-
NORCYCLOPROPA[g]TAX-11-ENE

- 5 This application claims the benefit of U. S. Provisional Application No. 60/482,598, filed June 26, 2003 and benefit of priority of French Patent Application No. 03/04,613, filed April 14, 2003.
- 10 The present invention relates to a novel process for the preparation of taxoids of general formula:



- 15 In the general formula (I),
 Ar represents an aryl radical,
 R represents a hydrogen atom or an acetyl, (C₃-C₆)
 alkoxyacetyl or (C₁-C₄) alkyl radical,
 R₁ represents a benzoyl radical or an R₂-O-CO- radical
 20 in which R₂ represents a straight or branched alkyl
 radical comprising 1 to 8 carbon atoms.

- Preferably, Ar represents a phenyl radical optionally
 substituted by one or more atoms or radicals chosen
 25 from halogen atoms (fluorine, chlorine, bromine or
 iodine) and alkyl, alkoxy, alkylthio, cyano, nitro and
 trifluoromethyl radicals, it being understood that the
 alkyl radicals and the alkyl portions of the radicals
 comprise 1 to 4 carbon atoms, or else Ar represents an

aromatic heterocyclic radical having 5 ring members and comprising one or more identical or different atoms chosen from nitrogen, oxygen or sulfur atoms.

- 5 More particularly, Ar represents a phenyl, 2- or 3-thienyl or 2- or 3-furyl radical.

More particularly still, Ar represents a phenyl radical optionally substituted by a chlorine or fluorine atom
10 or by an alkyl (methyl), alkoxy (methoxy) or 2- or 3-thienyl or 2- or 3-furyl radical.

Of even more particular advantage is the product of general formula (I) in which Ar represents a phenyl
15 radical, R₁ represents a tert-butoxycarbonyl radical and R represents an acetyl radical.

Mention may be made, among the processes known to date for preparing the compounds of formula (I), of patent
20 EP 0 673 372, which discloses, starting from 10-deacetylbaecatin III, a process which consists, in a first stage, in protecting the 10-deacetylbaecatin III in the 7 position, in a second stage, in acetylating in the 10 position, in a third stage, in deprotecting the
25 7 position, in a fourth stage, in carrying out a trifluoromethanesulfonylation (or triflation) in the 7 position, in a fifth stage, in carrying out a cyclopropylation in the 7-8 position, then, in a penultimate stage, in attaching the side chain in the
30 13 position and, finally, in a final stage, in deprotecting the side chain. The stage of cyclopropylation in the 7-8 position is carried out in the presence either of an alkali metal halide (sodium iodide, potassium fluoride) or of an alkali metal azide
35 (sodium azide) or of a quaternary ammonium salt or, finally, of an alkali metal phosphate.

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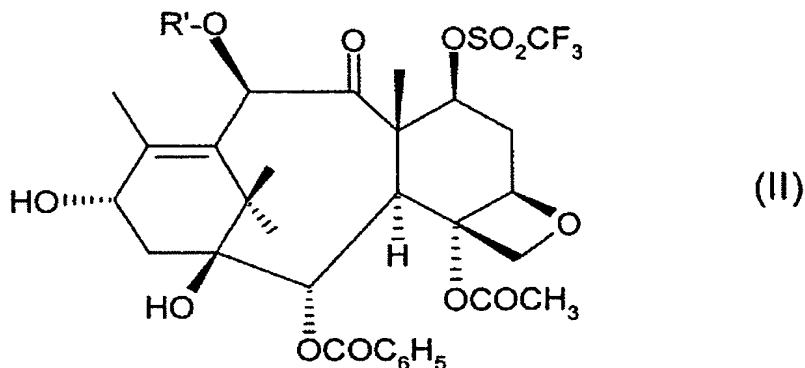
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baccatin III or 10-deacetylbaccatin III derivative of general formula:

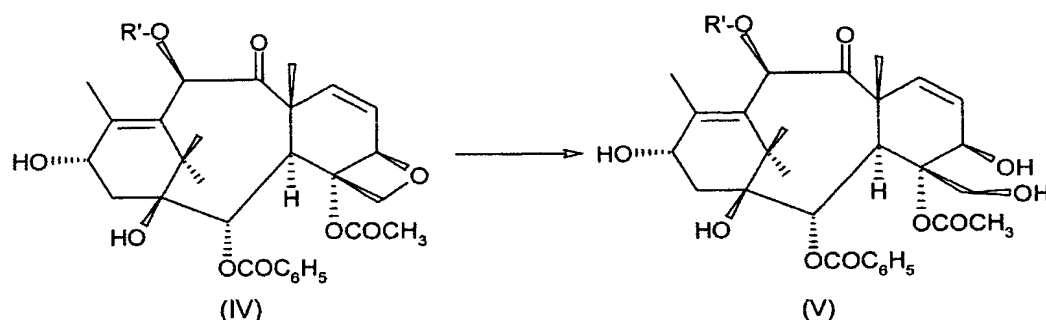


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in which R' is defined as above, the reaction taking place in sulfolane.

10 The product of general formula (I) will subsequently be obtained by coupling a precursor of the side chain to the derivative of formula (III) according to processes known to a person skilled in the art.

15 In an entirely preferred way, the cyclopropylation reaction is carried out in sulfolane comprising between 2 and 5% by weight of water. The presence of water makes possible the conversion of the derivative of formula (IV) below, a by-product produced during the cyclopropanation, to the derivative of formula (V); the
 20 separation of the derivative of formulae (III) and of the derivative of formula (IV) is difficult, whereas the separation of the derivative of formula (V) from the derivative of formula (III) is easier.



For better implementation of the invention, it is preferable to operate with an amount of water of approximately 4% by weight with respect to the sulfolane. The reaction temperature is in particular between 20°C and the boiling point of the reaction mixture.

10 The addition is carried out of preferably 25 to 100% by weight of molecular sieve with respect to the substrate. As regards the reaction conditions, the reaction is generally carried out between 20°C and the boiling point of the solvent for one to several hours.

15 According to a better process for implementing the invention, use will be made of the hydrated sulfolane (approximately 4% of water by weight) as reaction solvent in the presence of 100% by weight of 4 Å
20 molecular sieves as activated powder with respect to the substrate. In this case, the reaction will be carried out at a temperature in the region of 60°C until the substrate has been completely converted.

25 The product of formula (II) in which R' represents a
protective group for the hydroxyl functional group or
an acetyl, alkoxyacetyl or alkyl radical can be
obtained by reaction of a derivative of
trifluoromethanesulfonic acid, such as the anhydride or
30 the chloride, with baccatin III or 10-deacetylba-

III protected on its 10 position by a protective group, such as in particular trichloroethoxycarbonyl.

Generally, the reaction of a derivative of
5 trifluoromethanesulfonic acid is carried out in an inert organic solvent (aliphatic hydrocarbons, optionally halogenated, or aromatic hydrocarbons) in the presence of an organic base, such as a tertiary aliphatic amine (triethylamine) or pyridine, at a
10 temperature of between -50 and +20°C.

According to a better process for implementing the invention, where one of the preferred compounds of formula (III) where R represents an acetyl group is
15 prepared from the compound of formula (II) where R has the same meaning, after reaction of the compound of formula (II) with the molecular sieve:

- the crude product is isolated by a series of
20 treatments, such as the optional addition of a solvent, such as ethyl acetate, the removal of the insoluble materials by filtration, the concentration of the reaction medium and then the crystallization by addition of solvents which induce insolubility, such as
25 those chosen in particular from water or toluene,
- then either the crude product is purified by recrystallization from a solvent or solvent mixture, such as methanol, methanol as a mixture with diisopropyl ether or toluene, sulfolane as a mixture
30 with toluene, or methylene chloride as a mixture with diisopropyl ether, or ethyl acetate as a mixture with diisopropyl ether,
- or the crude product is purified by chromatography on silica gel, elution being carried out with methylene
35 chloride as a mixture with ethyl acetate, methanol or acetonitrile.

Preferably, the medium will be treated by addition of ethyl acetate, filtration of the molecular sieve, concentration under reduced pressure and precipitation by addition of water with seeding.

5

Preferably, the crude product will be purified by crystallization from an ethyl acetate/diisopropyl ether mixture with a ratio of between 50/50 v/v and 10/90 v/v.

10

The product of formula (III) obtained is subsequently or previously coupled according to methods known to a person skilled in the art with a precursor of the side chain chosen from β -phenylisoserine protected in the 2' position, such as disclosed in patent EP 366 840, oxazolidines, such as disclosed in particular in patents EP 595 370, EP 663 906, EP 663 907, EP 663 908, EP 666 857 and EP 669 915, or β -lactams, such as disclosed in particular in the following patents EP 400 971, US 5,254,580 and US 5,466,834.

All of the references described herein are incorporated herein by reference in their entirety.

25 The following examples illustrate the present invention but should not be regarded as a limitation on the invention.

EXAMPLE 1

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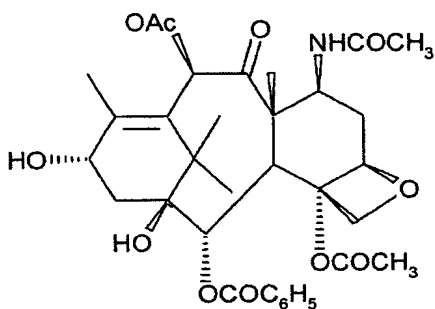
4,10 β -Diacetoxy-2 α -benzoyloxy-5 β ,20-epoxy-1,13 α -dihydroxy-9-oxo-7 β -(trifluoromethylsulfonyloxy) tax-11-ene (2.0 g) with a purity of 92%, 2.02 g of 4 Å molecular sieves as activated powder and 1.0 g of sodium chloride are charged to 14 ml of sulfolane in a 50 ml three-neck flask and the mixture is heated at 60°C for approximately 4 hours. The reaction medium is cooled to ambient temperature and then filtered. The

insoluble materials are washed in 3 times with 50 ml of ethyl acetate and the organic phases are combined. The 4,10 β -diacetoxo-2 α -benzoyloxy-5 β ,20-epoxy-1,13 α -dihydroxy-9-oxo-19-norcyclopropa[g]tax-11-ene (I) thus
 5 obtained is quantitatively determined by HPLC with respect to a standard (1.29 g, yield of 88%).

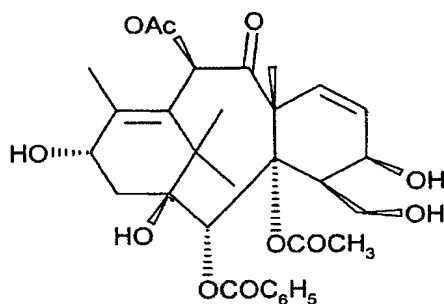
Comparative examples with different solvents

10 The results are shown in the following table:

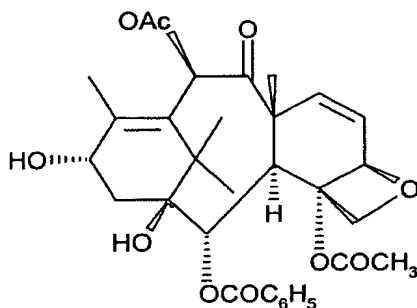
Example	Solvent	Conditions	DC	Yield	Observations
C1	AcCN/THF 10v/1v	15 g, reflux 3 hours	> 99%	69%	13.5% acetamido 7.7% ethylene-1
C2	DMF	0.5 g 40 - 50°C 7 hours 30	98%	70%	16.5% ethylen-2
C3	NMP	0.5 g 50°C, 3 hours	> 99%	12.6%	Decomposition
C4	Acetone	3 g reflux 2 hours	> 99%	-	5.6% ethylen-1 40% 7-epi OH



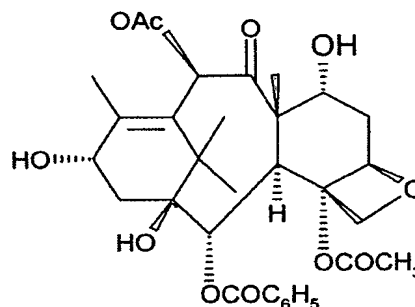
ACETAMIDO



ETHYLEN-1 or (V)



ETHYLEN-2 or (IV)



7-epi OH

EXAMPLE 2

5 4,10 β -Diacetoxy-2 α -benzoyloxy- β ,20-epoxy-1,13 α -
dihydroxy-9-oxo-7 β -(trifluoromethylsulfonyloxy) tax-11-
ene (60.0 g) with a purity of 89.8% by weight, 60 g of
4 Angstrom molecular sieves as activated powder and
9.6 ml of water are charged to 240 g of sulfolane in a
10 500 ml three-neck flask and the mixture is heated with
stirring at 60°C for approximately 4 hours. The
reaction medium is cooled to 40°C and 200 ml of ethyl
acetate are added. The suspension is filtered through
a bed of Dicalite and the insoluble material is washed
15 4 times with 50 ml of ethyl acetate. The organic
phases are combined and the 4,10 β -diacetoxy-2 α -
benzoyloxy-5 β ,20-epoxy-1,13 α -dihydroxy-9-oxo-19-
norcyclopropa[g] tax-11-ene thus obtained is
quantitatively determined by HPLC with respect to a
20 standard (37.5 g, yield of 88%). A fraction of the
solution (152 g) is concentrated under a pressure of
less than 15 mmHg at 45°C for approximately 45 minutes

and the concentrate obtained (75.2 g) is stirred at 40°C. 59.2 ml of demineralized water are added over one hour to the solution and then seeding is carried out at 40°C with 100 mg of 4,10 β -diacetoxy-2 α -
5 benzoyloxy-5 β ,20-epoxy-1,13 α -dihydroxy-9-oxo-19-norcyclopropa[g]tax-11-ene. The medium is cooled to ambient temperature over 2 hours 30 minutes and then 80.3 g of demineralized water are again run in over 1 hour. The suspension is then cooled to 0-4°C over
10 approximately 1 hour 30 minutes. The product is filtered off, washed 3 times with 33 ml of demineralized water and dried under reduced pressure at 45°C for 16 hours. 12.65 g of crude product are thus obtained, which product has a purity of 70.8% by weight
15 quantitatively determined by HPLC (yield of 83%).

12.5 g of crude product are charged to a 100 ml round-bottom flask and are dissolved in 25 ml of methanol at 55°C. The reaction medium is cooled to 35°C and then
20 seeded with a few mg of 4,10 β -diacetoxy-2 α -benzoyloxy-5 β ,20-epoxy-1,13 α -dihydroxy-9-oxo-19-norcylcopropa[g]tax-11-ene. The suspension is then cooled to ambient temperature and then to 0-4°C over approximately 3 hours. After filtration, the product is washed twice
25 with 5 ml of diisopropyl ether and then dried under reduced pressure at 45°C for 16 hours. 7.1 g of pure product are thus obtained, which product has a purity of 97.7% by weight quantitatively determined by HPLC (recrystallization yield of 66%).

30

EXAMPLES 3 to 5

Example 2 is repeated as far as the crude product, a variable amount of water being added to the sulfolane.

Example	Conditions	ETHYLEN-1	ETHYLEN-2
3	Sieve 60°C, 4 hours	3.6	5.5
4	Sieve 60°C, 4 hours, 1% water	6.9	2.4

5	Sieve 60°C, 4 hours, 2% water	7.9	1.4
2	Sieve 60°C, 4 hours, 4% water	8.7	0.2

The impurity named ETHYLEN-2 is difficult to separate from (III) by silica gel chromatography or crystallization; in contrast, the impurity named
5 ETHYLEN-1 is easily removed by these same techniques.

EXAMPLE 6 - Purification by crystallization from methanol

10 4,10 β -Diacetoxy-2 α -benzoyloxy- β ,20-epoxy-1,13 α -
dihydroxy-9-oxo-7 β -(trifluoromethylsulfonyloxy)tax-11-
ene (58 g) with a purity of 92%, 58 g of 4 angstrom
molecular sieves as activated powder and 29 g of sodium
chloride are charged to 580 ml of ethyl acetate in a 2-
15 liter glass reactor and the mixture is heated with
stirring at between 55 and 65°C for approximately 46
hours. The reaction medium is cooled to ambient
temperature and filtered through a bed of Clarcel and
the insoluble material is washed twice with 116 ml of
20 ethyl acetate. The organic phases are combined and the
4,10 β -diacetoxy-2 α -benzoyloxy-5 β ,20-epoxy-1,13 α -
dihydroxy-9-oxo-19-norcyclopropa[g]tax-11-ene solution
thus obtained is washed with an aqueous sodium
hydrogencarbonate solution (17.4 g in 290 ml of water)
25 and then twice with 290 ml of water. The reaction
medium is concentrated to a volume of approximately
200 ml under reduced pressure at a temperature of less
than 40°C and 825 ml of methanol are added. The change
in solvent is carried out by distillation under reduced
30 pressure at a temperature of less than 40°C with
addition of methanol (1145 ml in total) and then the
solution is cooled to ambient temperature.
Crystallization is initiated with 0.21 g of 4,10 β -

diacetox-2 α -benzoyloxy-5 β ,20-epoxy-1,13 α -dihydroxy-9-oxo-19-norcyclopropa[g]tax-11-ene and then the suspension is cooled to 0°C over approximately 1 hour and 30 minutes. The suspension is filtered and the product is washed twice with 116 ml of diisopropyl ether. After drying at ambient temperature to constant weight, 25 g of product are obtained (yield of 55%), which product assays at 94% by weight by HPLC quantitative determination (> 99% by area internal normalization).

EXAMPLE 7 - Purification by chromatography

The crude 4,10 β -diacetox-2 α -benzoyloxy-5 β ,20-epoxy-1,13 α -dihydroxy-9-oxo-19-norcyclopropa[g]tax-11-ene (4.9 g) with an HPLC purity of 93.9% (internal normalization of the areas) and assaying at 65.5% by weight are purified by chromatography with 250 g of silica gel, elution being carried out with a mixture of methylene chloride and ethyl acetate (v/v: 75/25). The fractions comprising the product are combined and concentrated under reduced pressure. The solution obtained (241 g) assays at 1.3% w/w by HPLC quantitative determination. The purity by HPLC is 99.4% (purification yield of 97%).

EXAMPLE 8 - Purification by crystallization from diisopropyl ether (DIPE)

The crude 4,10 β -diacetox-2 α -benzoyloxy-5 β ,20-epoxy-1,13 α -dihydroxy-9-oxo-19-norcylcopropa[g]tax-11-ene (23 g) with a purity of 91% by HPLC and assaying at 77.5% by weight are dissolved in approximately 640 ml of ethyl acetate and the organic phase obtained is washed twice with 255 ml of water. The solution is then concentrated under reduced pressure at approximately 30°C to a residual volume of approximately 74 ml. 222 ml of diisopropyl ether are then added to the

solution over 4 to 7 hours at ambient temperature and then the suspension obtained is cooled to 2°C. The suspension is cooled and the product cake is washed with 36 ml of diisopropyl ether. After drying under reduced pressure at 25°C, 17.6 g of purified 4,10 β -diacetox-2 α -benzoyloxy-5 β ,20-epoxy-1,13 α -dihydroxy-9-oxo-19-norcyclopropa[g]tax-11-ene are obtained, which product has a purity of approximately 97% and assays at 89.3% by weight (yield of 88%).

Example 8 is repeated in the following Examples 9 - 12 with different recrystallization solvents. The results obtained in these Examples 9 - 12 are tabulated below.

Example	Conditions	RY%	ETHYLEN-1 %	ETHYLEN-2 %
9	AcOEt/DIPE 27/75	88	0.3	-
10	MeOH/DIPE 70/30	82	1.7	0.2
11	MeOH/toluene 50/50	47	0.3	0.2
12	AcOEt/DIPE 50/50	88	0.2	-